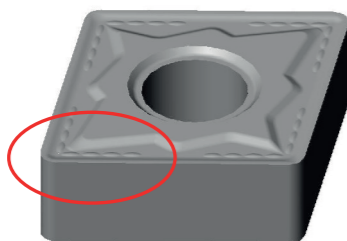


## NM Chipbreaker

We are now releasing two inserts with new chipbreakers, to be followed by other geometries:

• CNMG 120408 NM LT10

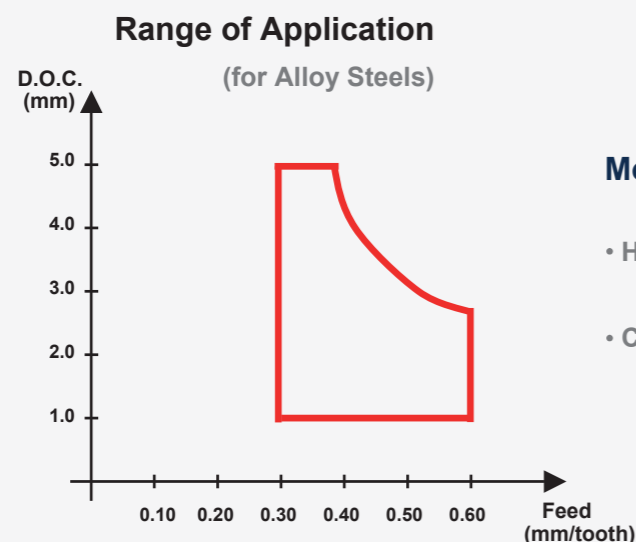


• WNMG 080408 NM LT10



### Main Advantages

- Chip jumping effect to delay craterization and increase tool life
- Extremely robust edge preparation
- Wide range of chip control (fragmentation range)



## Recommended Cutting Conditions

CNMG 120408 NM/ WNMG 080408 NM

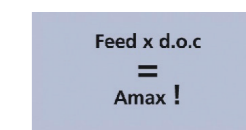
Material Group	No.	Material	Brinell	d.o.c [mm]		feed [mm/rev]		Vc [m/min]		Optimal cutting conditions				
				min	max	min	max	A max	min	max	d.o.c	feed		
Low Carbon Steel	1	CK15 CK45 1020 1045	150	0.5	5.0	0.27	0.68	2.33	180	330	4.0	0.45		
			180		5.0		0.68	2.33		280				
			210		5.0		0.60	1.95		250				
Alloy Steel	2	42 CrMo 4 St 50-2 CK60 1060 4140	180	0.5	5.0	0.27	0.60	1.95	120	280	4.0	0.35		
			230		5.0		0.60	1.50		250				
			280		5.0		0.53	1.50		210				
			320		4.0		0.53	1.28		180				
High Alloy Steel	3	X40 CrMoV 5 1 40 NiCrMo 6 S 2-10-1-8 H13 D2 HSS M42	220	0.5	5.0	0.23	0.60	1.50	70	190	4.0	0.30		
			280		5.0		0.60	1.50		150				
			320		4.0		0.53	1.20		130				
			350		4.0		0.53	1.20		100				
			400	0.5	3.5	0.14	0.45	0.90	50	90	3.4	0.36		
			480		3.0		0.35	0.68	40	80	2.9	0.30		
			550		2.5		0.28	0.45	30	70	2.5	0.25		
			NM Chipbreaker is not recommended for Austenitic Stainless Steel											
Austenitic and Duplex Stainless Steel	4	X5 CrNi 18 9 304	210 to 250											
			230 to 270											
				NM Chipbreaker is not recommended for Austenitic Stainless Steel										
X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----													
Ferritic Stainless Steel	7	X8 Cr 7 430	annealed	0.5	5.0	0.29	0.46	1.13	170	250	4.0	0.35		
Martensitic Stainless Steel	8	X15 Cr 13 410	annealed treated	0.5	5.0	0.29	0.46	1.13	170 120	250 190	4.0	0.35		
Grey Cast Iron	9	GG 20 GG 25 GG 30	140 to 230	0.5	5.0	0.20	0.90	2.25 2.03 2.03	170	250	4.0	0.60		
										230				
										210				
Nodular Cast Iron	10	GGG 40 GGG 50 GGG 70 G-X260NiCr42	210 260 310 450	0.5	5.0	0.20	0.70	1.73 1.50 1.35	120	230	4.0	0.50		
										190				
										150				
										30			50	1.2
Ni based Alloy	11	Inconel 625 Inconel 718 Hastelloy C	-----	NM Chipbreaker is not recommended for Exotic Alloy										
				TiAl 6 V4 T40	-----									



Ordering Information:



CNMG 120408 NM  
WNMG 080408 NM



Catalog Nr. T0001966  
Catalog Nr. T0001967